

	Doc or ECO #:	ECO-THR-TDS-STD-001	Date:	12/3/2020	Author:	SL
	Rev. #:	A				
Engineering Change Order (ECO)	Engineering Approval:	AEG	Date:	12/3/2020	Quality Approval:	aeg

P/N #:	THR-TDS-STD	Effective Date:	December 1, 2020
Title:	TDS Drum Reverse Engineering Corrections		

1.0 Purpose / Summary

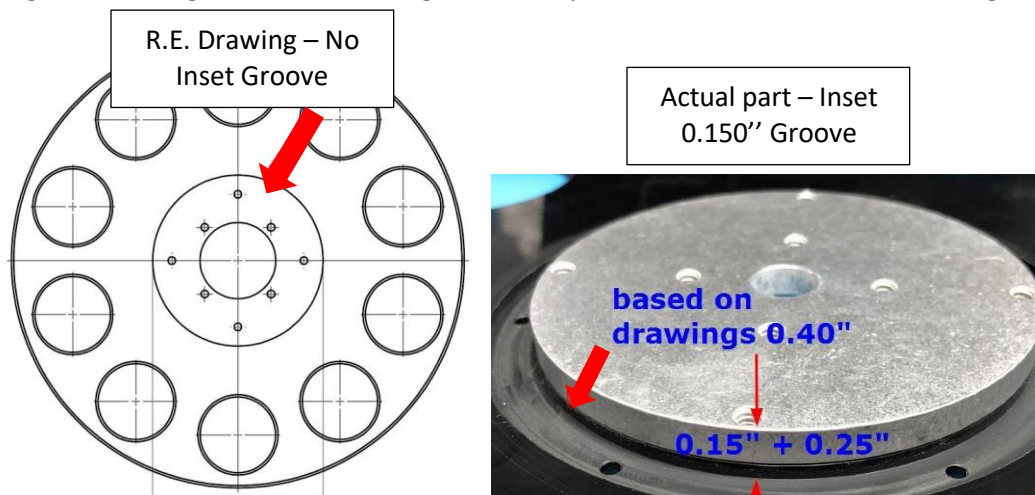
- The purpose of this ECO is to correct dimensions that were incorrect due to the nature of reverse engineering. Some features were not able to be accounted for as the unit cannot be disassembled.

2.0 Parts Affected

Part Number	Notes	Removed	Added	Modified	REV
TDS-001	Length increased to account for inset groove on TDS-002	☐	☐	☒	X-04
TDS-002	Updated to add inset groove	☐	☐	☒	X-04

3.0 Detail

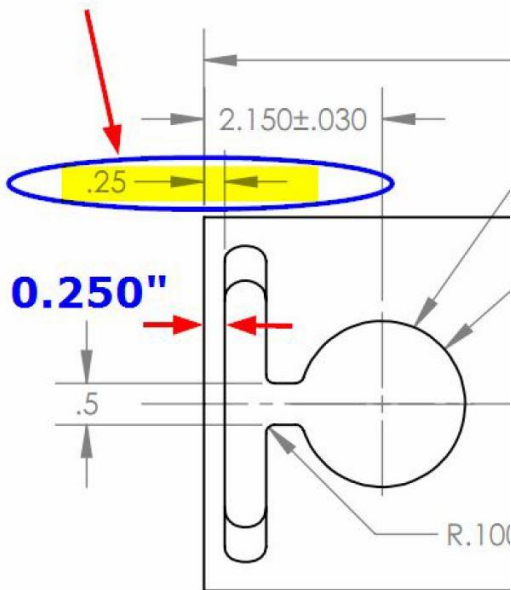
- Some features went unknown in the reverse engineering of TDS-001 & TDS-002. The lack of these important features caused the latest batch of Standard TDS's to have shorter drums causing Slip Ring failures do to excessive back and forth play inside the case.
- The reverse engineered drawing for TDS-002 did not have a 0.15" inset groove that the vendor included in the machined part due to older stock that was machined to the pre-reverse engineered design. TDS-002 Drawing has been updated to include the 0.150" inset groove.



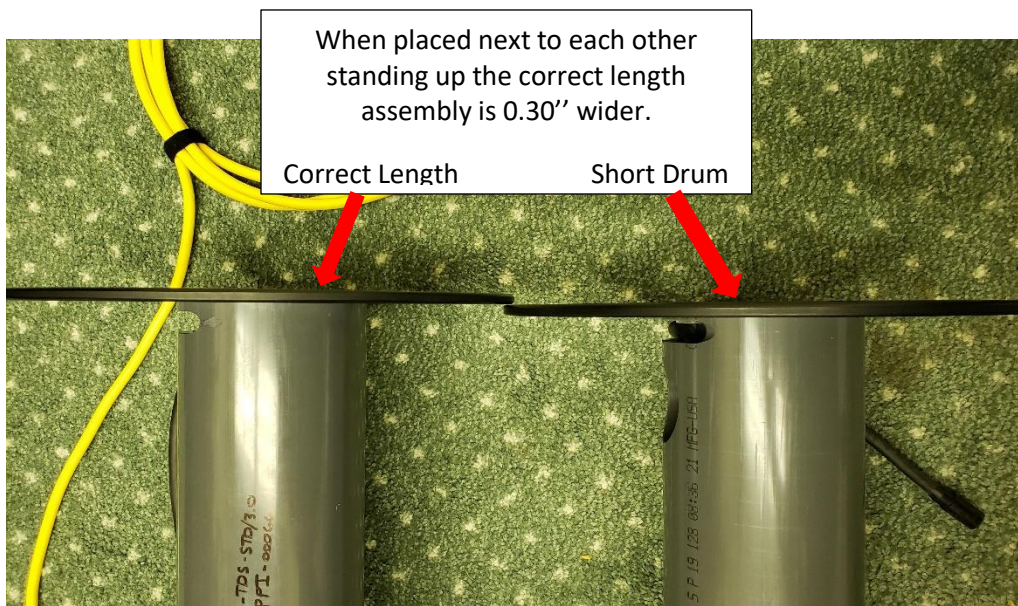
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- Due to the missing inset groove on TDS-002, the TDS-001 drum did not account for the extra length of 0.300" needed. TDS-001 Drum has added 0.150" to both ends to account for the inset groove in TDS-002.

TDS-001 Drum



Short drum easily identifiable by seeing if TDS-004 TDS Right Plate extends past tether pass through.



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4.0 Disposition of Material

- VideoRay does not purchase or manufacture these parts, standard TDS is provided turnkey from the supplier. Note, drawings at X-revs and un-revisioned parts entry in Epicor.
- PPI was provided reworked XDS reels to work into standard tds reels.
- Properly dispose of any short TDS-001-ASSM using the above information to identify which drum you have.

5.0 Action Items

Action	Department	Acknowledgement Initials
Correct Drawings	ENG	JV
Notify Vendor	ENG/Purchasing	SL/RM

6.0 Modified / Referenced Documents:

Document	Current Revision
TDS-001.pdf	X-04
TDS-002.pdf	X-04

7.0 Revision History

Date Revised (mm-dd-yyyy)	Location of Change (section, paragraph no., step no., etc.)	Description of Change Made	Name of Person making the Change
12/3/2020		Inti	SL